

Date: Monday, 3/26/2007 3:23:30 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206 EXTRUSION BENDING	
Job Number	31487				
Estimate Number	10311				
P.O. Number	N/A		Part Number	D2620	
This Issue	3/26/2007	S.O. No.	Drawing Number	D2620 REV B	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A	Type	Drawing Revision	B	
Previous Run	29388		Material	N/A	
Written By			Due Date	4/10/2007	
Checked & Approved By	HJ 07.03.27		Qty:	20 Um: Each	
Comment	Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26001160	Extrusion Round 3" 206	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Extrusion Round 3" 206 Pick; Qty Part Number Description Batch 1 D2600-1 Extrusion Round 3"206 30249 EL 7-3-29			
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
Comment: LANDING GEAR RESOURCE 1 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2- Cut Fwd end of tube as per Dwg D2620 BE 07-04-04 (40) EL/K 07-03-29 (40)			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP BE 07-04-04 (40)			
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LG BE 07-04-04 (40)			
5.0	QC21	FINAL INSPECTION/W/O RELEASE	
Comment: FINAL INSPECTION/W/O RELEASE BE 07-04-05 (40)			
Job Completion H 07-04-05			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

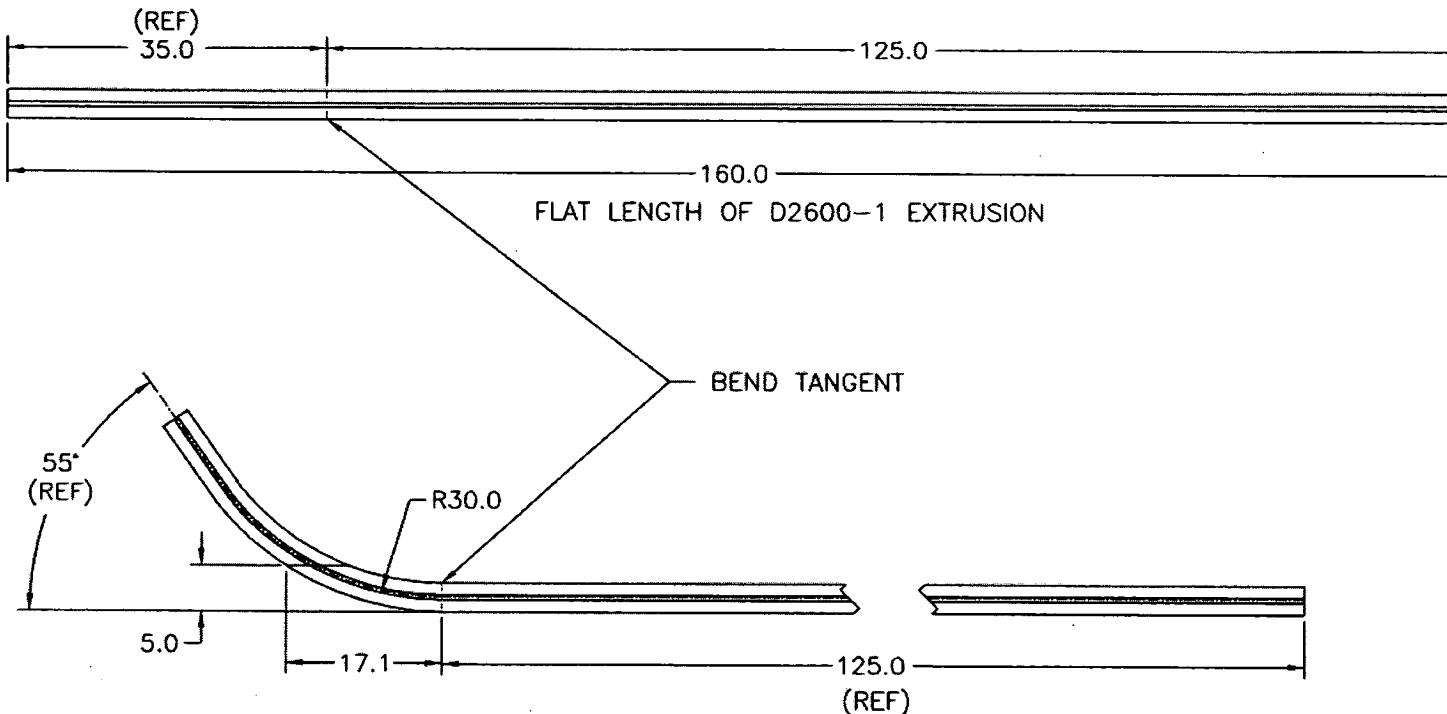
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
SHOUPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
4. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
5. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
6. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART

3 COPY
GANT

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
	RF	FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED	APPROVED	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	
99.09.10	D2620	SHEET 1 OF 1
A	97.11.07	TITLE
B	97.09.10	206 SKIDTUBE BENDING CONTROL
		SCALE
		1:20

RELEASED
49-04-15
DS

UNCONTROLLED COPY
REMOVED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31487

